

Date: Monday, 08/09/2008 2:50:43 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : JACK SADDLE
Job Number : 41888	
Estimate Number : 11177	
P.O. Number :	Part Number : D2281
This Issue : 08/09/2008 S.O. No. :	Drawing Number : D2281 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : G
Previous Run : 39817	Material :
Written By :	Due Date : 30/10/2008 Qty: 50 Um: Each
Checked & Approved By : <u>JUL 08.9.08</u>	
Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM Est: rev B 06.07.17 waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S14GA	304SS sheet .080
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Comment: Qty.: 0.1313 sf(s)/Unit Total : 6.5625 sf(s)
 304SS .080
 batch: 109358 18 8-9-23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2281
 Dwg Rev: G
 Prog Rev: G

18 8-9-23

(54)

2-Deburr if necessary

18 8-9-23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

18 8-9-23

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

50869/23

counts

(54)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: Deburr

18 Done at step 2.2

50869/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/09/2008 2:50:43 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 41888

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

JB 08/10/07 (54)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/07 counter (X54)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 266

JS 08/10/08 (X54)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08 JA

Job Completion



u 08.10.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41888
Description: Jack Saddle		Part Number: D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.472	*			
4.114	+/-0.010	4.113	*			
2.933	+/-0.010	2.933	*			
1.535	+/-0.010	1.537	*			
0.354	+/-0.010	.356	*			
0.354	+/-0.010	.354	*			
0.604	+/-0.010	.604	*			
2.000	+/-0.010	2.000	*			
3.396	+/-0.010	3.396	*			
3.646	+/-0.010	3.645	*			
4.000	+/-0.010	4.008	*			
1.525	+/-0.010	1.529	*			
2.475	+/-0.010	2.478	*			
Ø0.323	+0.006/-0.001	.324	*			
0.080	+/-0.010	.075	*			

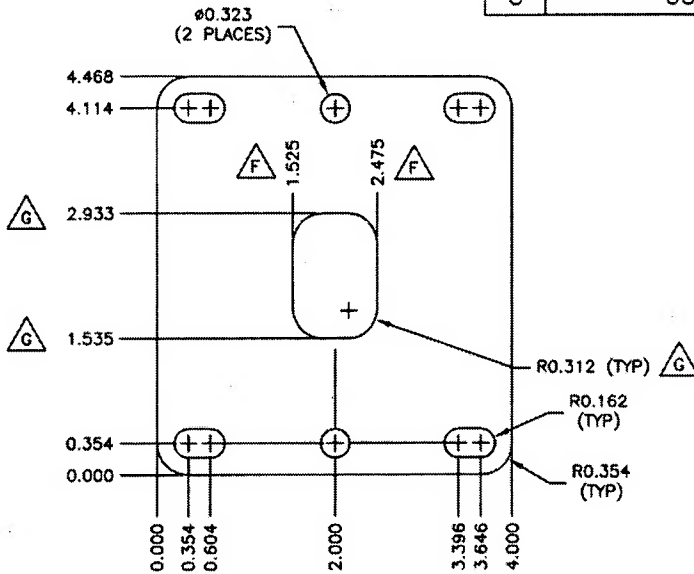
Measured by: RB	Audited by: C	Prototype Approval:	N/A
Date: 8-9-23	Date: 08/09/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	

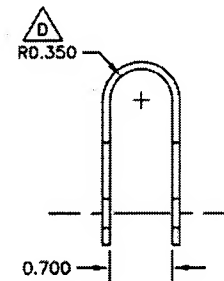
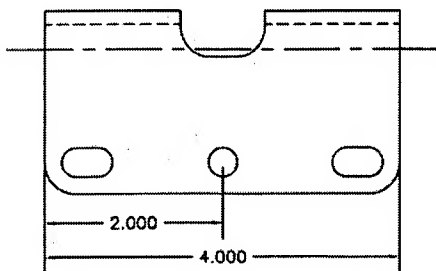


DESIGN BW	DRAWN BY <i>FB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>MS</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
MS
05/08/11



FLAT LAYOUT



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 41838

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